



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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D3492-1
Job Sheet 197884



Part No: D3492-1 Job Qty: 100 pcs
Part Name: Plug
Part Weight: 0 lbs Status: New Priority: Medium
Job Created: 7/18/19 Job Tracking No:
Due Date: 7/30/19 Created By: Marie Lajeunesse
Type: Stock Description:
Note: DWG REV E IPP Rev:A 11.04.19 per dwg revC DD verf:EC
Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Hardinge - 1	100 pcs	7/30/19	7/30/19	0.50	3.06	Hardinge - 1		BM-19-08-12
120	QC 8	100 pcs	7/30/19	7/30/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		87 19-08-14
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
150	Handfinish - 1-1 Chemical-B4B	100 pcs	7/30/19	7/30/19	0.00	0.33	Handfinish - 1 - 1 - B4B		
							Handfinish - 1 - 2 - B4B		
							Handfinish - 1 - 3 -		AUG 16 2019

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Container No: S204549



Part: D3492-1
Job No: 197884
Serial No/Batch: S204549

Revision:
Inspector:
Exp Date:
Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 08/12/19

				B4B	
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
160	Powdercoat - 1 White Gl(A)- B4B	100 pcs	7/30/19	0.00 0.16	Powdercoat - 1 - B4B
					Powdercoat - 2 - B4B
					Powdercoat - 3 - B4B
					Powdercoat - 4 - B4B
170	QC 3	100 pcs	7/30/19	0.00 0.00	QC 3 - 10
					QC 3 - 13
					QC 3 - 15
					QC 3 - 17
					QC 3 - 18
					QC 3 - 2
					QC 3 - 28
					QC 3 - 3
					QC 3 - 30
					QC 3 - 34
					QC 3 - 36
					QC 3 - 41
					QC 3 - 51
					QC 3 - 58
					QC 3 - 59
					QC 3 - 68
					QC 3 - 9
					QC 3 - 40
					QC 3 - 19
					QC 3 - 43

BK 19-800

START 11:15 OUT 3:30 FRESH 11:45

AUG 27 2019 9:59

DAS 40

180 Packaging 3-1 - Stock - B4B	100 pcs	7/30/19	0.00 0.00	QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
				Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	

				Packaging 3 - 36 - B4B			
190 QC 21 - SA	100 pcs	7/30/19	0.00 0.00	QC 21 - SA - 21	DAS 70 9-89	AUG 23 2019	DAS 77 9-89
				QC 21 - SA - 70			
				QC 21 - SA - 53			
Part Op 100 - (Hardinge) 1-Turn as per Folio FA633 & Dwg D3492 Dwg Rev: <u>E</u>							
Descriptions: 120 - (QC8- Inspect parts - second check)							
150 - (Chemical Conversion Coat per QSI005 4.1)							
160 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) (Flat End Only) START TIME: _____ FINISH TIME: _____							
170 - (QC3- Inspect Part Finish)							
180 - (Identify as per dwg & Stock Location: _____) LOCATION : FP001							
190 - (QC21- Final Inspection - Work Order Release)							
Job BOM							
Part / Item	Component Name	Quantity	Operation	Container			
M6061T6R0.625	6061-T6 Round Bar .625"	5.3000 ft (.053 ea)	100-Hardinge - 1	S180 494			
				S150604			
Job Allocations							
Operation	Component Part	Required	Inventory	Allocated			
100-Hardinge - 1	M6061T6R0.625	5	26	0			
Part Specifications							
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments		
1	Plug	0.060inches ± 0.005	0.065 0.055	0.059			
2	Plug	0.060inches ± 0.005	0.065 0.055	0.060			
3	Plug	0.394inches ± 0.010	0.404 0.384	0.392			
4	Plug	0.625inches ± 0.010	0.635 0.615	0.621			
5	Plug	0.090inches + 0.000 - 0.002	0.090 0.088	0.888			
6	Plug	0.500inches ± 0.010	0.510 0.490	0.504			
7	Plug	0.050inches + 0.000 - 0.002	0.050 0.048	0.049			
8	Plug	0.050inches ± 0.010	0.060 0.040	0.051			
9	Plug	20.000Degrees ± 0.000	20.000 20.000	20°			

MAT used
4.833'
1.583'

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DAS 52 9-89 19/08/13

NCR No. _____		Job: _____												Part No. _____																																	
Date : _____		Sequence #:				QTY Affected :				MRB (QSI042)																																					
Description Work Order Deviation		Disposition																																													
Root Cause Operator Manufacturing Process Equip/Tooling Handling/Preservation Material Product Improvement Process Improvement Human Factors		DISPOSITION												DEPARTMENT/PROCESS																																	
		Rework Scrap Use-as-is												Skid-tube Machining Large Fab Cross tube Small Fab Finishing Eng. (Non-AW) Prod. Eng. Coord. Rec/Store/Packaging Engineering Water Jet Supplier Quality																																	
Completed By												Lead hand / Supervisor												QC / QA Coordinator																							
Root Cause												FAULT CATEGORY																																			
Pressure/Forced Bending Crushing Cracks Crimp/Kink/Ripple/Wave/Twist Marks/Chatter Mislabeled Other/Details:												Contamination Misaligned/off center BOM/Route Broken/Damage/Defect Incomplete/Unclear Instructions Drill Holes Fit/Function												Power Loss/Surge Folio/Program Grain Direction Weld Wrong Stock Pulled Out of Sequence Off-set/Set-up												Positioned Wrong Outside Tolerance Drawing Finish Part Lost/Missing Misread											